

Work Order ID 88524

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August-02-12 11:49:27 AM

Item ID: D3204-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Release Pedal Assembly
 Start Date: 7/27/12 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 8/24/12 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 12-08-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3204	Rev A1

100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1- Weld assembly as per Dwg D3204 using Jig D3204-041T1. 2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld. 3- Use JB weld compound to plug the hole after assembly. 4- Grind JB weld flush after it is cured.								

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

19 12-11-19

H 12-11-20 DAS 18 2-83

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Item ID: D3204-041 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 8/24/12 Req'd Qty: 6.00 ***6*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4			
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
140 *140* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo ***Cover holes for bushing*** START TIME: OVEN TEMPERATURE: FINISH TIME:	0.00 0.00							

m122966

12-03
3200 F
12-30

4X ✓ m/z 12/11/21

4X ✓ m/z 12/11/21

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N900040100

Setup Start *NS1*

Stop *NS2*

6

Cust Item ID:

Required Date: 8/24/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Insp.
Stamp

0.00

150

OC

Memo

0.00

Quality Control

160

0.00

160

Small Fab

Small Fab

Memo

0,00

Small Fab

Install D3204-7 bushing as shown in Dwg D3204

170

QC5- Inspect part completeness to step on W/O

0.00

170

OC

Memo

0.00

Quality Control

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Item ID: D3204-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Release Pedal Assembly

Start Date: 7/27/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/24/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>CA</u>	0.00				4			<u>12/11/22</u>
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							<u>12/11/23</u>
190									
QC	Memo	0.00							
Quality Control									<u>ME</u> <u>12-11-23</u>

Picklist Print

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[Signature]

Work Order ID: 88524
Parent Item: D3204-041
Parent Item Name: Release Pedal Assembly

Start Date: 7/27/12 Required Date: 8/24/12
Start Qty: 6.00 Required Qty: 6.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3204-1 Tube		Manufactured	No	88332 x4		100	Each	0.0000	1	6		EL 12-11-14	
D3204-11 Plate		Manufactured	No			100	Each	12.0000	1	6		EL 12-11-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				88362 x4.	WA	12							
					86778	12							
D3204-13 Gusset		Manufactured	No			100	Each	14.0000	2	12		EL 12-11-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		14							
					85984	14							
D3204-3 Arm		Manufactured	No			100	Each	15.0000	1	6		EL 12-11-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		10							
					86709	10							
				WA019		5							
					79804	5							
D3204-5 Arm		Manufactured	No			100	Each	14.0000	1	6		EL 12-11-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		14							
					85982	4							
					86702	10							

Picklist Print

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Work Order ID: 88524

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 7/27/12

Required Date: 8/24/12

Start Qty: 6.00

Required Qty: 6.00

D3204-7
Bushings

Manufactured No

160 Each 41.0000

2

12

Location

Loc Qty

Loc Code

GA

41

77091

1

85981

40

D3204-9

Pedal

Manufactured No

100 Each 19.0000

1

6

Location

Loc Qty

Loc Code

WA

19

85980

9

87104

10

8 12-1-14 4

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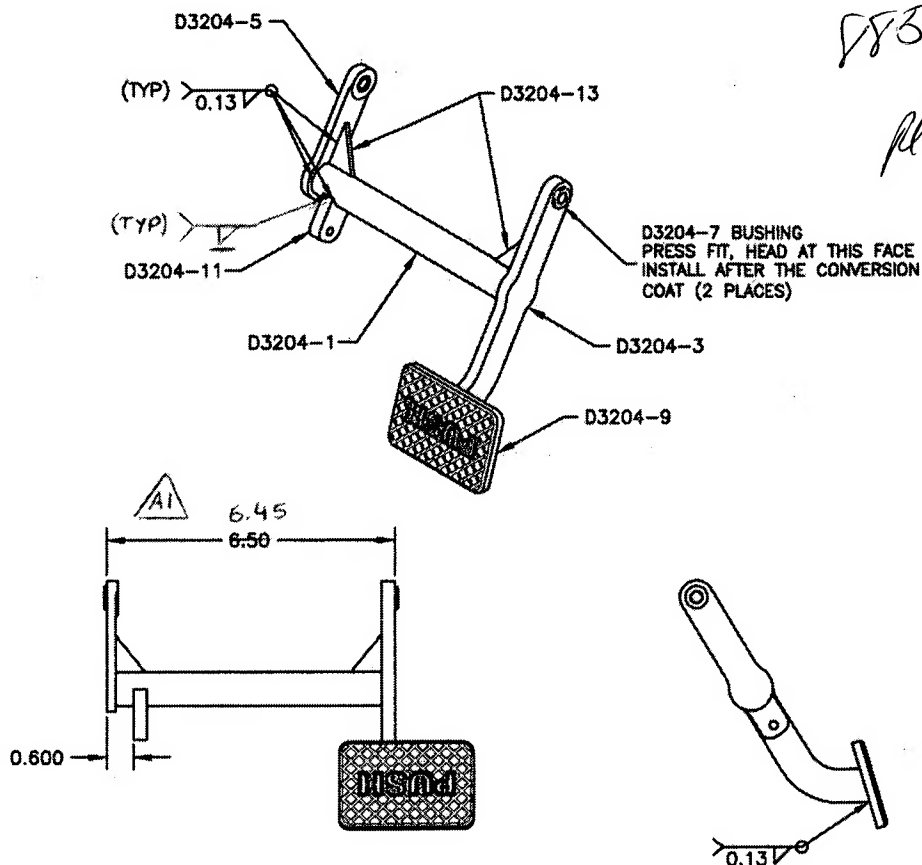
Shop Packet Print

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

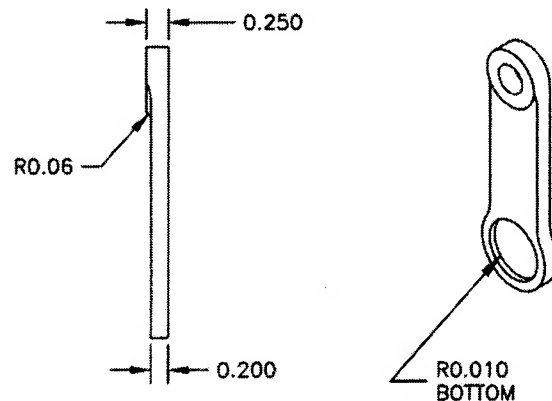
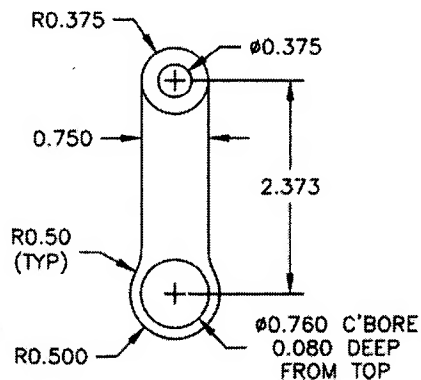
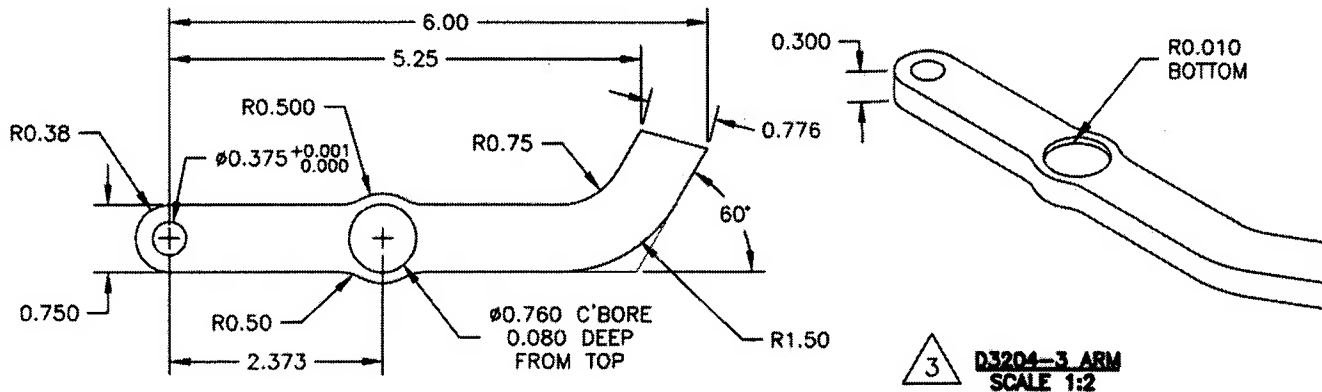
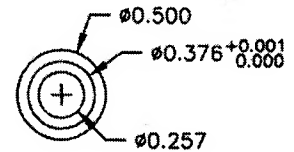
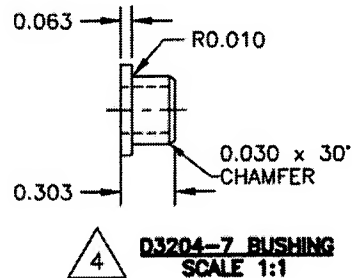
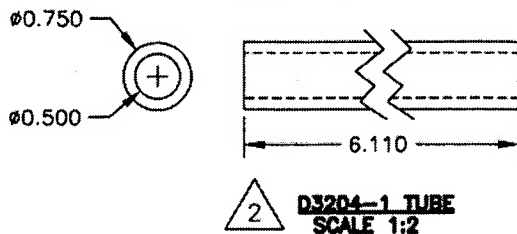
- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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CHECKED R	APPROVED R	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

RELEASED
04.04.05

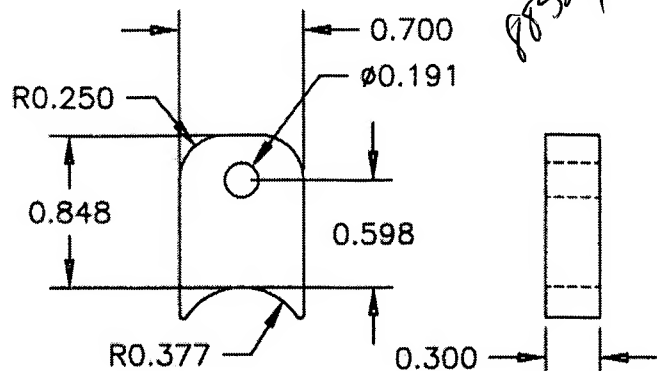
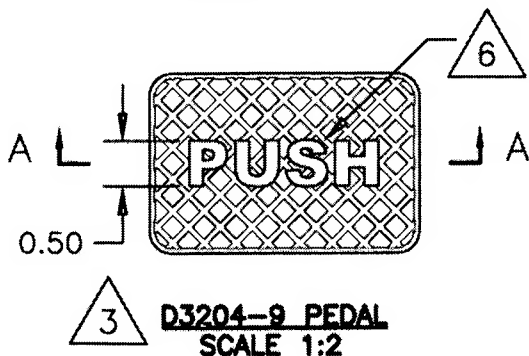
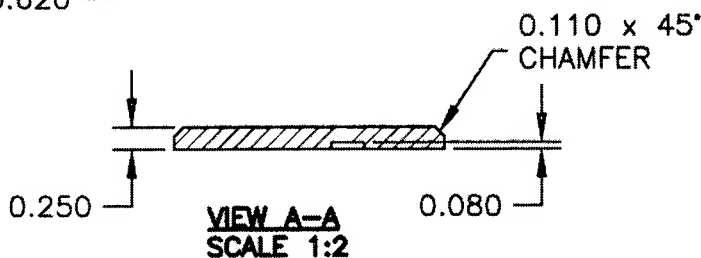
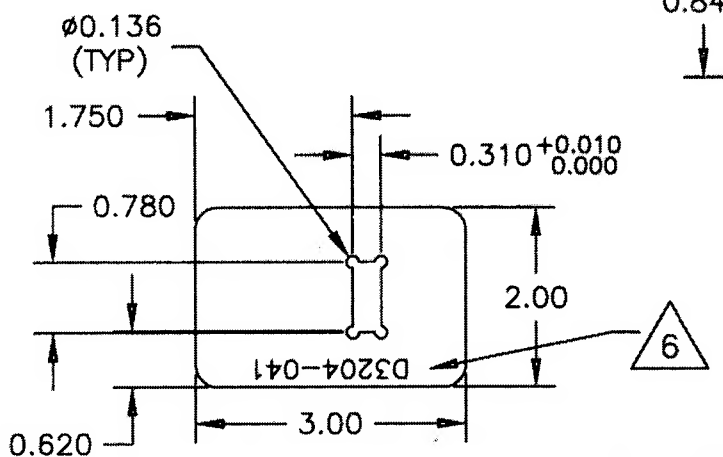
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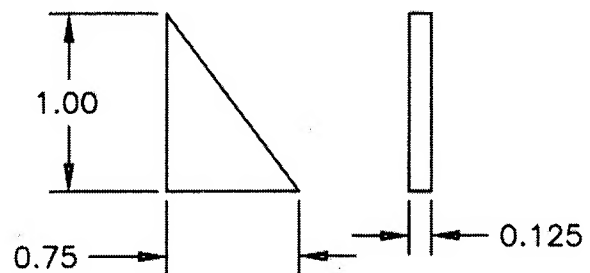


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

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04.04.30



D3204-11 PLATE
SCALE 1:1



D3204-13 GUSSET
SCALE 1:1

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